

ABSTRACT

Chillers (4) rapidly remove heat from a coupling of cam pieces (6) immediately after molten metal is injected, so as to make the coupling of cam pieces (6) chilled (be a white cast iron). As a result, tensile strength and shear strength of the coupling of cam pieces (6) decreases while the coupling of cam pieces (6) becomes harder. Cam piece original shapes and notches are alternately formed in the coupling of cam pieces (6). The notch of the coupling of cam pieces (6) which is being held by a holder is hit by a breaking tool. Then, the coupling of cam pieces (6) with low tensile strength breaks at the notch which is the vulnerable portion so that an individual cam piece is obtained.